

Work Order ID 68382-1

Tuesday, April 12, 2011 1:23:36 PM

Page 1

Item ID: D3912-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Eyebolt Receiver Assembly

Start Date: 4/12/2011 Start Qty: 6.00

Required Date: 4/15/2011 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-12 Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3912

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

110

0.00



Small Fab

Memo

0.00

Small Fab

1-Assemble D3912-1/-3/-5 and install rivets as per dwg
TRIM RIVETS 1.250" LONG

2- Install helical, spring plunger and spring pin lanyard assy as per dwg

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Split

2

[Signature]

ESa/04/26 (2)

ES11/04/26 (2)

Sulzer

(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 68382



Tuesday, April 12, 2011 1:23:36 PM





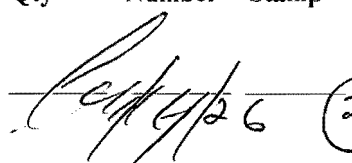
Page 2

Item ID: D3912-041 Accept  Setup Start 
Revision ID:
Item Name: Eyebolt Receiver Assembly Stop 
Start Date: 4/12/2011 Start Qty: 6.00  Cust Item ID:
Required Date: 4/15/2011 Req'd Qty: 6.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: <u>507</u> Memo	0.00 0.00							
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Handwritten notes:
11/4/27 
MF
11-04-27

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 1:23:42 PM

Page 1

Work Order ID: 68382

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly




Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: new issue DD 09.11.18 verified by:EC IPP Rev:B
10.06.10 memo in seq110 ***IF PLUNGER GOES IN TO DEEP, INSTALL A
WASHER (AN960C516L) IF NECESSARY BETWEEN PLUNGER AND
D3912-1. YOU MAY HAVE TO ENLARGE WASHER HOLE FOR IT TO
FIT*** DD verf:JLM IPP REV:C AS PER REV B 10-08-05 JLM
VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149C0663R  Washer		Purchased	No				Each	253.0000		6		4/11/04/26	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST297				253				2	
				110139				53					
				116893				200					
D3912-1  Eyebolt		Manufactured	No			100	Each	3.0000	1	6		4/11/04/26	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST091				3				2	
				65095				3					
D3912-3  Eyebolt Block		Manufactured	No			100	Each	1.0000	2	12		4/11/04/26	
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>													
				ST091				1				1	
				66320				1				368378 (3x)	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 1:23:43 PM

Page 2

Work Order ID: 68382

Parent Item: D3912-041

Parent Item Name: Eyebolt Receiver Assembly

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 6.00

Required Qty: 6.00

D3912-5 Manufactured No

100 Each

7.0000

2

12



Eyebolt Plate

Location

Loc Qty

Loc Code

ST091

7

66160

7

Each

3.0000

D3801-1

Manufactured No



Hand Retractable Spring Plunger

Location

Loc Qty

Loc Code

ST084

3

65630

3

100

Each

252.0000

8

48

MS20615-4M20

Purchased

No



RIVET

Location

Loc Qty

Loc Code

GA

252

117071

252

Each

58.0000

6

MS21209-F615

Purchased

No



Heli-Coil

Location

Loc Qty

Loc Code

ST305

58

108170

37

108244

21

EPB 11/04/26
318381

4
EPB 11/04/26

2
EPB 11/04/26

16
6
EPB 11/04/26

2

W/O:		WORK ORDER CHANGES					
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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

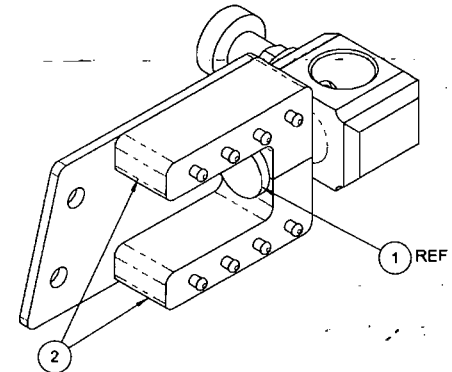
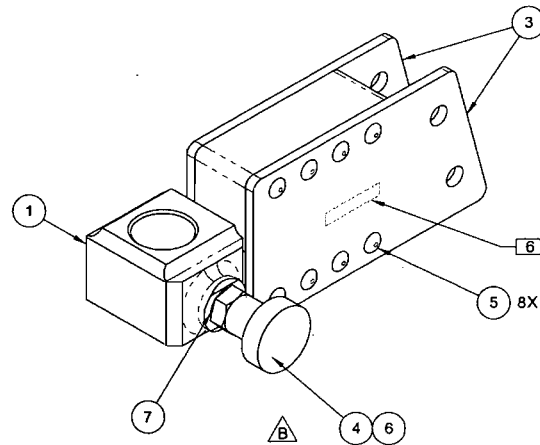
WITHOUT NOTICE

WORK ORDER

NO. 68382

2111-04-12

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3912-041	EYEBOLT RECEIVER ASSY
1	1	D3912-1	EYEBOLT
2	2	D3912-3	EYEBOLT BLOCK
3	2	D3912-5	EYEBOLT PLATE
4	1	D3801-1	SPRING PLUNGER
5	8	MS20815-4M20	RIVET
6	1	MS21209-F615	HELICAL
7	1	NAS1149F0332P	WASHER



SUPPLEMENTAL ISO VIEW
(EYEBOLT PLATE REMOVED
TO SHOW INTERIOR FEATURES)

D3912-041 EYEBOLT RECEIVER ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3912-041 USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.58 lbs

RELEASED
2010-07-16

B	D3801-1 WAS D3810-1 SPRING PLUNGER; D4028-041 RMV; MS21209-F615 WAS MS21209-C610 HELICAL; (1) WASHER NAS1149C0683R ADDED; BOSS ADDED TO D3912-1.	JPH	10.06.28
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	1.5		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.06.28		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3912
TITLE EYEBOLT RECEIVER ASSY
REV. B
SHEET 1 OF 3
SCALE NTS

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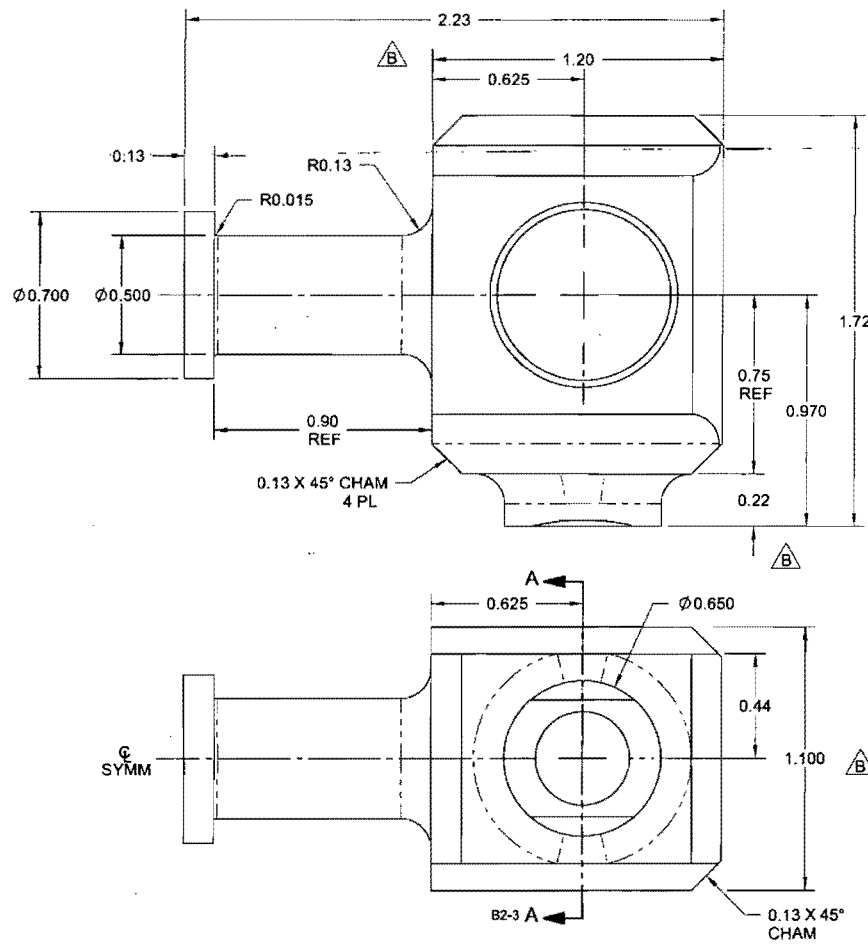
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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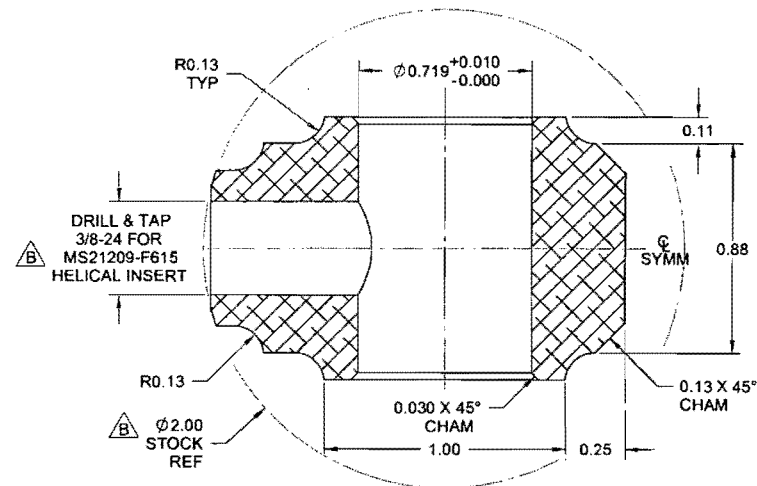
NOTE: Date & initial all entries



D3912-1 EYEBOLT

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
REF DART SPEC M303R OR M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ID AT ASSEMBLY
- 7) WEIGHT: 0.45 lbs



SECTION A-A B6-3

RELEASED
2010-07-16

DESIGN	ASS	DART AEROSPACE LTD	
DRAWN	JL	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JL	DRAWING NO.	REV. B
MFG. APPR.	JL	D3912	SHEET 2 OF 3
APPROVED	JL	TITLE	SCALE
DE APPR.	A	EYEBOLT RECEIVER ASSY	NTS
DATE	10.06.28	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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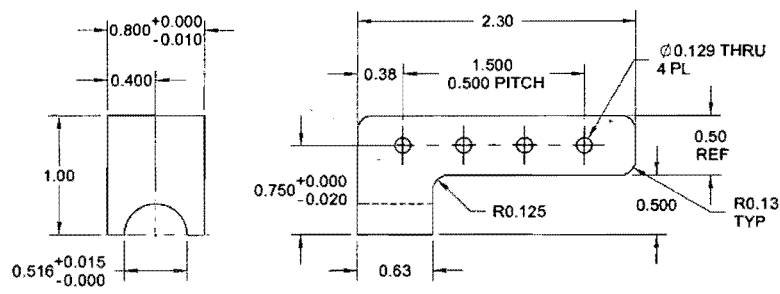
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

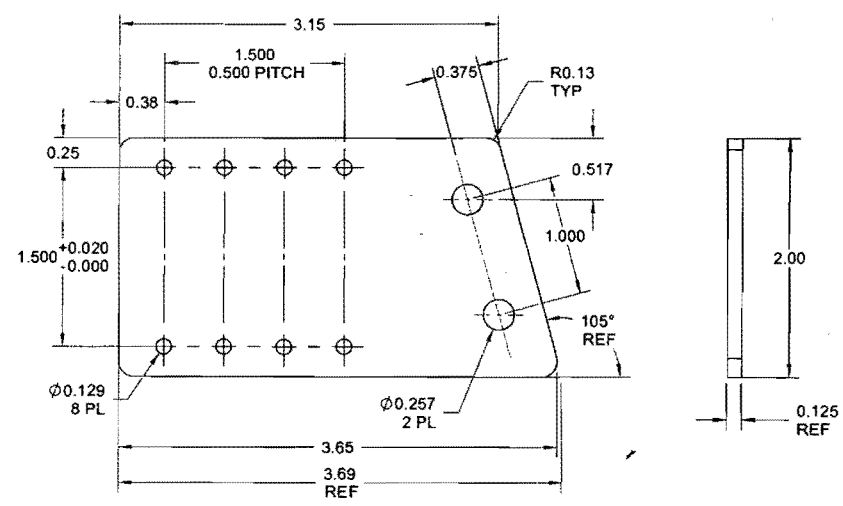
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NOTE: Date & initial all entries

W/O 68382



D3912-3 EYEBOLT BLOCK



D3912-5 EYEBOLT PLATE

- NOTES:
- 1) MATERIAL -3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ID AT ASSEMBLY
 - 7) WEIGHT -3: 0.30 lbs
-5: 0.24 lbs

RELEASED
2010-07-16

DESIGN	1.5	DART AEROSPACE LTD	
DRAWN	1.5	HAWKESBURY, ONTARIO, CANADA	
CHECKED	1.5	DRAWING NO.	REV. B
MFG. APPR.	1.5	D3912	SHEET 3 OF 3
APPROVED	1.5	TITLE	SCALE
DE APPR.	1.5	EYEBOLT RECEIVER ASSY	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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